

Date: Monday, 04/02/2008 3:13:51 PM
 User: Dominique Dube

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	407 STEP ASSEMBLY
Job Number :	37013		
Estimate Number :	11795		
P.O. Number :		Part Number :	D206628033
This Issue :	04/02/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	25/01/2008	Project Number :	N/A
Previous Run :	33923	Drawing Revision :	
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	10/03/2008
Written By :			Qty: 4 Um: Each
Checked & Approved By :			
Comment :	Est Rev:D As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROLPhotocopy blue file and type labels as per PPP D206-628-033 CHG ~~002~~ 003 per ECN 1118

2.0	37013A	FLOAT STEP ASSEMBLY LH (206/407)
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**Comment:** Sub-Component SUB-ASSEMBLY

206B STEP ASSY, LH

D2842-041 B 37013 A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

UPDATED AS PER ECN 1118, D206-268-033 .CHG NUM. 003

4.0	D27313	Mounting Lug
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number Description

4 D2731-3 Mounting Lug

Batch

M33995

50

5.0	D28441	Arm
-----	--------	-----

**Comment:** Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D2844-1

Arm M37243

8/3/07 50 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 04/02/2008 3:13:51 PM
User: Dominique Dube

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37013

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D28443

Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2844-3

Arm

1334876

(2x)

1337338

(2x)

SP

7.0

D2732030

Rubber Cushion



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part #

Description

Batch

8 D2732-030

RUBBER CUSHION

1534717

SP

8.0

D3394041

LUG ASS'Y



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D3394-041

LUG ASS'Y

30991

(12x)

34833

(4x)

SP

9.0

AN3C4A

BOLT



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C4A

Bolt

M105559

SP

10.0

AN4C14A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN4C14A

Bolt

M107087

SP

11.0

AN4C15A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN4C15A

Bolt

M103915

5/3/450

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37013

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960C10

WASHER



Comment: Qty.: 3.0000 EACH(s)/Unit Total : 12.0000 EACH(s)

Pick:

Qty Part Number Description

Batch

3 AN960C10 WASHER

M106302

SP

13.0

AN960C416L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number Description

Batch

24 AN960C416L Washer

M105793

SP

14.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number Description

Batch

24 NAS1515H4L Washer

M105408

SP

15.0

MS210434

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number Description

Batch

12 MS21043-4 Nut (or MS21042-4)

M107101

SP

16.0

NAS1515H3

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description

Batch

3 NAS1515H3 Washer

M106431

8/3/11 SP

44

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/3/11 44

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 28/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:07 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 STEP ASSEMBLY

Job Number: 37013

Part Number: D206628033

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-628-033

Location: _____

PPP Rev: _____

8/3/11

SD

(42)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

2008/03/10

Job Completion



2008/3/11

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:07 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 STEP ASSEMBLY
 Job Number : 37013
 Estimate Number : 11795
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206628033
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : N/A
 Previous Run : 33923 Drawing Revision :
 Material :
 Due Date : 3/10/2008 Qty: 4 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-033 CHG 002

2.0 37013A FLOAT STEP ASSEMBLY LH (206/407)



Comment: Sub-Component SUB-ASSEMBLY
 206B STEP ASSY, LH
 D2842-041 B_____

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

4.0 D27313 Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
 Pick:

Qty Part Number Description Batch
 4 D2731-3 Mounting Lug _____

5.0 D28441 Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Pick: Packing Kit
 Qty Part Number Description Batch
 2 D2844-1 Arm _____

628-033

Dart Aerospace Ltd.

Date: Friday, 1/25/2008 10:58:18 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT STEP ASSEMBLY LH (206/407)
 Job Number : 37013A
 Estimate Number : 11664
 P.O. Number :
 This Issue : 1/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2842041
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2842 REV B
 Previous Run : 33921A Material :
 Written By : Due Date : 3/10/2008 Qty: 4 Um: Each
 Checked & Approved By : SA 08 01 25
 Comment : Est Rev:D As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	<u>B3568</u>

Check Material for any Dents or Defects

SAD 08/02/26 4

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842

2-Drill D2842-1 using Jig DT8271 as per Dwg D2842

3-Deburr and bevel ends for welding

SAD 08/02/26 4

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	<u>B36520</u>

SA 08-02-26 4

4.0 D34593 plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37013A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

2 D3459-3 Lug

B34430

1/2 08.02.25 4

5.0

D34591

plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3459-1 Lug

B34429

1/2 08.02.25 4

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld one end cap and (2) lugs using Jig DT

followed by DT

as per Dwg D2842

A/R

AL Rod

Batch:

m105058
m106764

2-Grind end cap weld flush

SAD 05/03/03 (04)

1/2 08.02.25

7.0

~~QCS~~ *QCS*

INSPECT WORK TO CURRENT STEP



inspect welding

Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-03 (14)

8.0

~~QCS~~ *QCS*

VISUAL WELDING INSPECTION



inspect work to current step

Comment: VISUAL WELDING INSPECTION

PD 08/03/03 (14)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

1/2 08-03-04 (KCI)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

1/2 08.03.04 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37013A

Part Number: D2842041

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove alodine prior to welding.

Weld end cap as per Dwg D2842.

A/R AL Rod Batch: M106762
M105058

2-Grind end cap weld flush.

8/08.03.04

SAO 08/03/06 (4)

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 08-03-06 (4)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/06 (4) (1X)
08/03/06 (4X)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Touch-up Alodine end cap and Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Touch-up alodine m-h 08/23/06
08/23/06

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/03/06 (4)

16.0

NAS1329C3KB130

insert



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Insert

Pick:

Qty Part Number

Description

Batch

3

NAS1329C3KB130

Insert

M105385 (x3) M106951 (x9)

FD

17.0

MS27039C107

screw



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

MS27039C1-07

Screw

M106785

FD 08/03/10 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 02/03/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 1/25/2008 10:58:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOAT STEP ASSEMBLY LH (206/407)

Job Number: 37013A

Part Number: D2842041

• Job Number:



Seq. #:

Machine Or Operation:

Description:

18.0

NAS1515H3L

WASHER



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

NAS1515H3L

WASHER

m106516

FL

19.0

AN960C10L

washer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3

AN960C10L

WASHER

m107242

FL

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: LARGE FABRICATION RESOURCE 1

1-Install inserts as per Dwg D2842

2-Wing Walk as per Dwg D2842 and QSI 005 4.1

Batch: *m106894*

FL

08/03/10

(4)

21.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

FL

08-03-10

(4)

22.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD 37013

FL

08/03/10

(4)

23.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/10

(4)

Job Completion



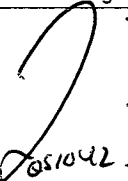
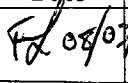
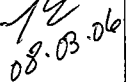
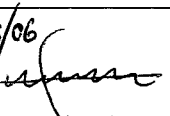
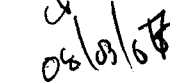

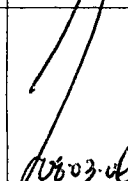
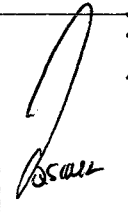
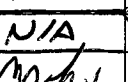
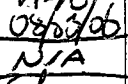
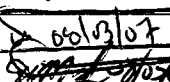
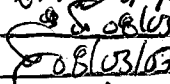
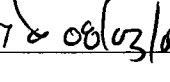
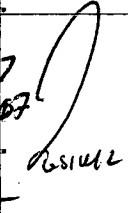
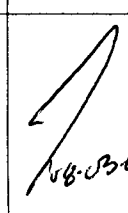
2008/3/11

(4)

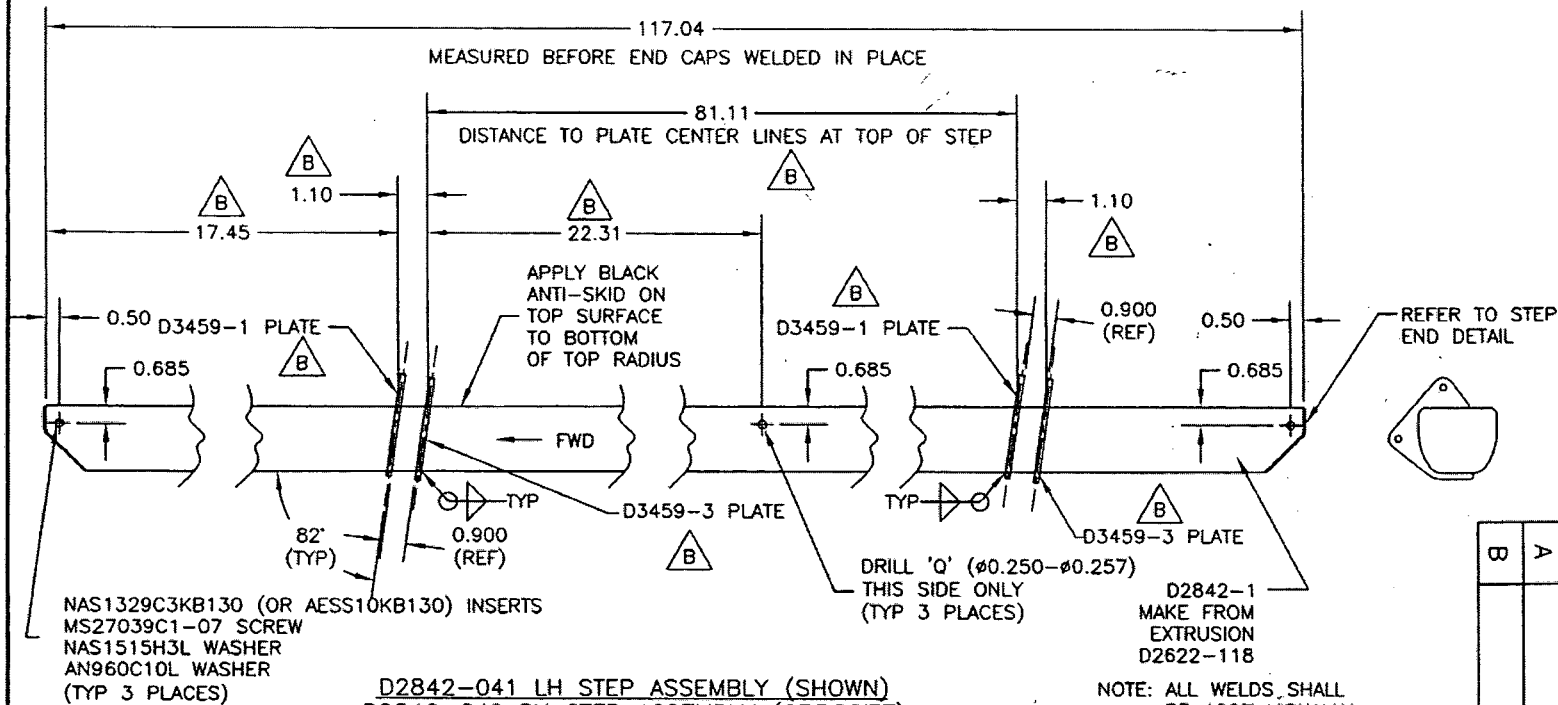
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-03-06	20.0	1 step only. The insert did not sit flat on the step upon installation.		<ul style="list-style-type: none"> CAREFULLY remove insert & not enlarge hole. Drill hole in the end cap to remove foreign object. Fill hole with weld per QS1004 & grind flush 	 08/03/06  08-03-06	  08/03/06		
↓	↓	~		<ul style="list-style-type: none"> Inspect re-powdercoat step per QS1005 re-inspect QC3 install qty 1 insert 	N/A  08/03/06 N/A  08/03/07	 08/03/07  08/03/07  08/03/07		

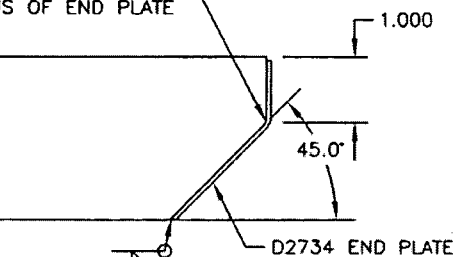
NOTE: Date & initial all entries

DART**D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST**

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D2842-041	LH STEP ASSEMBLY
		D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
370134



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED

05-11-14

DESIGN	DRAWN BY	DART Aerospace USA, Inc.	
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
05.09.23	98.10.13	D2842	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.23	05.09.23	206L/407 FLOAT STEP ASSEMBLY	NTS
A	B	NEW ISSUE	
		RE-DESIGN, ADD D3459-1/-3	